Tuesday, 11/6/2007 3:42:48 PM Kim Johnston **Process Sheet** : PLATE **Drawing Name** : CU-DAR001 Dart Helicopters Services Customer Job Number : 35591 : 10425 **Estimate Number** : D32191 **Part Number** P.O. Number - D3219 REV A S.O. No. : **Drawing Number** : 11/6/2007 This Issue Project Number : N/A : NC Prsht Rev. : SMALL /MED FAB : A **Drawing Revision** : 11 Type First Issue Material : 35080 Previous Run : 11/28/2007 Each Qty: 100 Um: Due Date Written By Checked & Approved By New issue KJ/JLM 04.04.19 Comment : Est. Waterjet ESR B 06.05.25 **Additional Product** Job Number: Description: Machine Or Operation: Seq. #: 6061-T6 .125 Sheet 1.0 M6061T6S125 63333 10.1220 sf(s) Comment: Qty.: 0.1012 sf(s)/Unit Total: 6061-T6 .125 Sheet To be made in multiples of 4 Material: 6061-T6 (QQ-A-200/11) 0.125" thick B 67-11-8 (M6061T6S.125) Batch: 105646 FLOW WATER JET 2.0 WATER JET Comment: FLOW WATER JET 1-Cut as per Dwg D3219 Dwg Rev:____ 13 07-11-8 Prog Rev:____ INSPECT PARTS AS THEY COME OFF MACHINE 3.0 QC2 HR 07-11-8 Comment: INSPECT PARTS AS THEY COME OFF MACHINE SECOND CHECK 4.0 QC8 Comment: SECOND CHECK 5.0 SMALL FAB 1 Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Deburr if necessary.

Dart Ae	rospace L	td							
W/O:			WC	ORK ORDER CHANGE	S				
DATE STEP		PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No:		PAR #:	Fault Cate	gory:	NCR: Yes	No DQA	:	Date:	· · · · · · · · · · · · · · · · · · ·
					QA: N	I/C Closed	:	_ Date: _	
NCR:	,	V	VORK ORDE	ER NON-CONFORMAN	ICE (NCF	R)			
DATE	OTED	Description of NC		Corrective Action Section	В	Verifica	ation	Approvai	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign 8 Date	Sectio		Chief Eng	QC Inspector
							ţ		
									·

NOTE: Date & initial all entries

Date: Tuesday, 11/6/2007 3:42:48 PM User: Kim Johnston **Process Sheet** Drawing Name: PLATE Customer: CU-DAR001 Dart Helicopters Services Part Number: D32191 Job Number: 35591 Job Number: Description: Seq. #: Machine Or Operation: INSPECT WORK TO CURRENT STEP 6.0 QC5 Comment: INSPECT WORK TO CURRENT STEP PACKAGING RESOURCE #1 Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 12 FINAL INSPECTION/W/O RELEASE 8.0 Comment: FINAL INSPECTION/W/O RELEASE a 8.11.14 Job Completion

Dart Ae	rospace	Ltd			•					
W/O:		4.*.	V	ORK ORDER CH	ANGES					
DATE STEP		PROCEDURE CHANGE				Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	•	PAR #:	Fault Cat	egory:	NC	R: Yes I	No DQ	A:	Date:	
						QA: N/	C Close	d:	_ Date: _	
NCR:			WORK ORI	DER NON-CONFO	RMANCE	(NCR)			
DATE	OTED	Description of NC	Corrective Action Section				Verification		Approval	Approval
DATE	Section A Initial Action Desci		Action Descrip Chief Eng	otion	Sign & Section C			Chief Eng	QC Inspector	
								i		
					•					
	1									ĺ

NOTE: Date & initial all entries



DART AEROSPACE LTD

Description: Plate

Part Number: D3219-1

Inspection Dwg: D3219 Rev: A

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.316	+0.005/-0.000	.317	ملا			,
2.293	+/-0.005		*			
2.965	+/-0.010	2.965	*			
0.566	+/-0.010	.566	*			
0.375	+/-0.010	375	*	:		
R0.125	+/-0.010	,(3 <u>S</u>	×			
0.125	+/-0.010	161,	¥			
13.9°	+/-0.5°				-111	

Measured by: \B	Audited by:		Prototype Approval:	N/A
Date: 07-11-8	Date:	Hulos	Date:	N/A

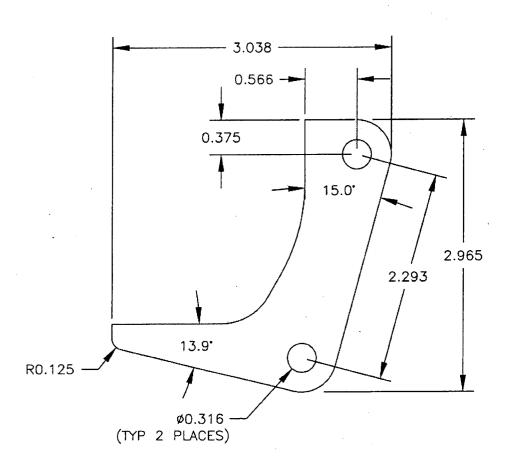
Rev	Date	Change	Revised by	Approved
A (04.04.19	New Issue	KJ/JLM	
ВС	07.09.06	13.9° dimension added	KJ/JLM	E





DESIGN (DRAWN BY		AEROSPACE LTD KESBURY, ONTARIO, CANADA
CHECKED,	APPROVED,	DRAWING NO.	REV. A
-#	- -	D3219	SHEET 1 OF 1
DATE		TITLE	SCALE
03.10.1	0	PLATE	1:1
Δ	03.10.10	NEW ISSUE	





D3219-1 PLATE

- 1) MACHINE PER DWG FILE "D3219-1.SLDPRT"
- 2) MATERIAL: 6061-T6, 0.125 THICK (QQ-A-250/11) (REF DART SPEC M6061T6S.125)
- 3) FINISH: NONE
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

SHOP COPY RETURN TO ENGINEERING UNCONTROLLED COPY SUBJECT TO AMENDMENT WITHOUT NOTICE

Copyright © 2003 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.